

Work Order ID 83236

83236

Page 1

April-16-12 11:03:59 AM

Item ID: D205-706-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Fuel Purge Canister

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-706	Rev A								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	Photocopy bluefile and create labels per PPP D205-706-013	CHG002							
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control	Memo								

Handwritten notes and signatures:

238 12/04/16

for MLJ 12-6-12

12/06/12

QC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83236

83236

Page 2

April-16-12 11:03:59 AM

Item ID: D205-706-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fuel Purge Canister

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-706-013								
	Location: 22								
	PPP Rev: D								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

mf
12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-16-12 11:04:02 AM

Page 1

Work Order ID: 83236

83236

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM IPP Rev:F 10.05.10 as per
chg002 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-5A Bolt		Purchased	No			110	Each	1,510.000	4	4			
----------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

AN3-5A

Location	Loc Qty	Loc Code
ST350	1510	
115371	46	
117423	124	
118626	147	
119355	200	
120187	500	
121185	493	

AN814-6D Plug		Purchased	No			110	Each	5.0000	1	1			
------------------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

AN814-6D

Location	Loc Qty	Loc Code
ST324	5	
117946	5	

AN815-6D Union-M-Flare		Purchased	No			110	Each	14.0000	2	2			
---------------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

AN815-6D

Location	Loc Qty	Loc Code
ST325	14	
119396	6	
119433	2	
119438	6	

M122087 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-16-12 11:04:02 AM

Page 2

Work Order ID: 83236

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

83236

D205-706-013

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN833-6D Purchased No

110 Each

4.0000

AN833-6D

Elbow, Bulkhead-M-Flare

**

Location

Loc Qty

Loc Code

ST328

4

119546

4

AN924-6D Purchased No

110 Each

12.0000

AN924-6D

Nut

**

Location

Loc Qty

Loc Code

ST329

12

120693

12

AN960JD10 NAS1149D0363J Purchased No

110 Each

0.0000

AN960JD10

Washer

**

AN960JD10L NAS1149D0332J Purchased No

110 Each

0.0000

AN960JD10L

Washer

**

AN960JD916 NAS1149D0963L Purchased No

110 Each

0.0000

AN960JD916

WASHER

**

D2001-4 Manufactured No

110 Each

13.0000

D2001-4

Valve Assembly (1/4")

**

Location

Loc Qty

Loc Code

ST002

13

77058

3

77201

10

77058

April-16-12 11:04:02 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

April-16-12 11:04:02 AM

Page 3

Work Order ID: 83236

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

83236

D205-706-013

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3262-041

Manufactured No

110 Each

1.0000

D3262-041

Canister Assembly

**

81547 JB

Location

Loc Qty

Loc Code

ST198A

1

79828

1

D3264-1

Manufactured No

110 Each

3.0000

D3264-1

Bracket

**

1182254 JB

Location

Loc Qty

Loc Code

ST198A

3

79348

3

D3297-1-0121

Manufactured No

110 Each

3.0000

D3297-1-0121

HOSE ASS'Y

**

1181920
82745 JB

Location

Loc Qty

Loc Code

ST191

3

76200

3

D3297-1-0130

Manufactured No

110 Each

4.0000

D3297-1-0130

HOSE ASS'Y

**

82747 JB

12/06/12

Location

Loc Qty

Loc Code

ST191

4

55069

1

76202

3

April-16-12 11:04:02 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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April-16-12 11:04:02 AM

Work Order ID: 83236

83236

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3297-3-0350

Manufactured No

110

Each

2.0000

D3297-3-0350

HOSE ASS'Y

**

82749 JB



Location

Loc Qty

Loc Code

ST192

2

47420

1

58005

1

D3298-001

Manufactured No

110

Each

9.0000

D3298-001

Tube Assembly

**

JB



Location

Loc Qty

Loc Code

ST192

9

47421

3

48507

6

D3298-009

Manufactured No

110

Each

3.0000

D3298-009

Tube Assembly

**

48507
82758 JB



Location

Loc Qty

Loc Code

ST192

3

47506

3

D3299-1

Manufactured No

110

Each

7.0000

D3299-1

Fitting

**

JB



12/06/12

Location

Loc Qty

Loc Code

ST037

7

42170

7

42170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

April-16-12 11:04:02 AM

Page 5

Work Order ID: 83236

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

83236

D205-706-013

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3299-3

Manufactured No

110 Each

3.0000

D3299-3

Fitting

**

Location

Loc Qty

Loc Code

ST037

3

75978

3

110

Each

3.0000

D3301-1

Manufactured No

D3301-1

Placard

**

Location

Loc Qty

Loc Code

ST037

3

77598

3

110

Each

16.0000

D3301-3

Manufactured No

D3301-3

Placard

**

Location

Loc Qty

Loc Code

ST037

16

77203

6

77856

10

110

Each

1.0000

D3302-1

Manufactured No

D3302-1

Doubler

**

Location

Loc Qty

Loc Code

ST198

1

73094

1

110

Each

0.0000

D3302-3

Manufactured No

D3302-3

Doubler

**

April-16-12 11:04:03 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

April-16-12 11:04:03 AM

Page 6

Work Order ID: 83236

83236

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,917.000

4 4

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2917

117441

16

117885

32

118451

5

118927

3

119017

1697

119075

164

121349

1000

MS21919-WDG12

Purchased

No

110

Each

32.0000

0 1

**

MS21919-WDG12

Clamp

Location

Loc Qty

Loc Code

ST307

32

107534

2

110985

30

MS21919-WDG16

Purchased

No

110

Each

5.0000

2 2

**

MS21919-WDG16

Clamp

Location

Loc Qty

Loc Code

ST296

5

119546

5

MS21919-WDG9

Purchased

No

110

Each

200.0000

5 5

**

MS21919-WDG9

Clamp

Location

Loc Qty

Loc Code

328

200

120986

200

April-16-12 11:04:03 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-16-12 11:04:03 AM

Page 7

Work Order ID: 83236

83236

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-42

Purchased

No

110

Each

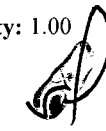
12.0000

MS21920-42
CLAMP(per MIL-DTL-8783C)

**

2 ✓

JB



Location

Loc Qty

Loc Code

ST451

12

119659

8

119673

4

MS28778-6

Purchased

No

110

Each

17.0000

MS28778-6
Packing

**

119673
5 ✓

JB



Location

Loc Qty

Loc Code

FP002

2

118354

2

ST294

15

117591

15

MS35489-11

Purchased

No

110

Each

18.0000

MS35489-11
GROMMET

**

3 X 117591
1 ✓

JB



12/06/12

Location

Loc Qty

Loc Code

ST295

18

109166

8

119537

10

109166

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER

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Revision: A

Date: 04.11.30

2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS2192042	CLAMP
10	5	5	MS2877856	O-RING
1	1	1	MS35489511	GROMMET

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Revision: **A**

Date: 04.11.30